


Process Sheet

Part Number : 41232 200 001 002
Drawing Number : 41232-200-001 REV IR
Project Number : N/A
Drawing Revision : IR
Material : 
Due Date : 4/2/2007

Qty: 5 Um: Each

Job Number:



MS208224 elbow



elbow

Batch: M 103688

5

07/04/15

G

20.	124K002 4CR 0545	Hose ass'y-Step Actuator
-----	------------------	--------------------------



Hose ass'y-Step Actuator

BATCH: M104042

3.0	AN8424D	Elbow
-----	---------	-------



Elbow

Batch: M 104014

40	41232 200 007 001	Brass Cylinder Assembly
----	-------------------	-------------------------



Brass Cylinder Assembly

Batch: 630942

5.0	41232 200 003 001	Spring (Step Actuator)
-----	-------------------	------------------------



~~Spring (Step Actuator)~~

Batch: ~~B 30941~~

9/1/0704-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 2:59:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 31451

Part Number: 41232 200 001 002

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	MS1699623	cap screw
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
cap screw
Batch: M 103984

7.0	AN3154R	Nut
-----	---------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Nut
Batch: M 17566

8.0	AN960JD416	Washer
-----	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Washer
Batch: M 103338

9.0	AN960JD10	Washer
-----	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Washer
Batch: M 103641

10.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Nut
Batch: M 102658

11.0	AN322A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Bolt
Batch: M 3413

12.0	41232 200 005 003	Spacer (Step Actuator)
------	-------------------	------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Spacer (Step Actuator)
Batch: B 31022

SB 07604/10

⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PP Date: 07/04/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 2:59:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH ACTUATOR ASSEMBLY

Job Number: 31451

Part Number: 41232 200 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 002 005

pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

pivot arm

Batch: B31021

14.0

41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

latch

Batch: B31020

SB 07/04/13 (5)

15.0

41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

tube

Batch: B31019

SB 07/04/13 (5)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

SB 07/04/13 (5)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/04/13 (5)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SB 07/04/13 (5)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/04/13 (5)

Job Completion



SB 07/04/13

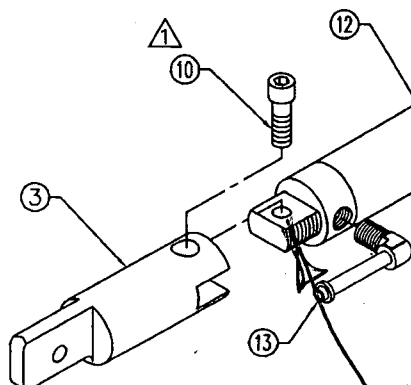
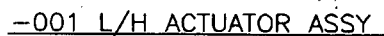
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

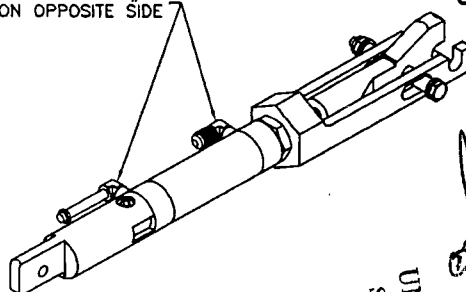
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





NOTE: Date & initial all entries



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR AS

-  TORQUE 80-100 IN.-LB.
 TORQUE 20-25 IN.-LB.
 TORQUE 50-75 IN.-LB.
 TORQUE 50-75 IN.-LB.

NOTES:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

			1	1	15	3/4x20 BRASS	CYLINDER NUT								
			1	1	14	MS20822-4	ELBOW								
			1	1	13	AN842-4D	ELBOW								
			1	1	12	41232-200-007-001	CYLINDER								
			1	1	11	71459	SPRING								
			1	1	10	MS16996-23	CAP SCREW								
			1	1	9	AN315-4R	NUT								
			2	2	8	AN960JD416	WASHER								
			2	2	7	AN960JD10	WASHER								
			1	1	6	MS21042-L3	NUT								
			1	1	5	AN3-22A	BOLT								
			2	2	4	41232-200-005-003	SPACER								
			1	1	3	41232-200-002-005	PIVOT ARM								
			1	1	2	41232-200-002-003	LATCH								
			1	1	1	41232-200-002-001	TUBE								
						-002	R/H ACTUATOR ASSY								
						-001	L/H ACTUATOR ASSY								
			-002	-001	FWD NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE				
LIST OF MATERIAL															
PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROPRIETARY TO ERA AVIATION INC. REPRODUCING OR USE OF THESE DATA FOR ANY PURPOSE IS PROHIBITED WITHOUT AUTHORIZATION FROM ERA AVIATION INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.			NO. REQ'D PER ASSY		PART NO.		UNLESS OTHERWISE SPECIFIED X ± .1 XX ± .03 XXX ± .010 ANGLES ± .1/2		DRAFTSMAN	D. NELSON	5/20/02	TITLE STEP ACTUATOR ASSY			
									CHECK	D. MURPHY	5/20/02				
									STRESS						
									PRGAL ENGR.			DWG. SIZE	C	SCALE	NONE
									HEAT TREAT					DWG. NO.	41232-200-001
									FINISH	Era Aviation, Inc.					